

Date: Wednesday, 19/12/2007 10:01:07 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 WEARPLATE
 Job Number : 36445
 Estimate Number : 12651
 P.O. Number : N/A Part Number : D35651
 This Issue : 19/12/2007 S.O. No. : N/A Drawing Number : D3565 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : U/R
 Previous Run : 36279 Material : N/A
 Due Date : 20/12/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev :A New Issue 07-01-16 JLM
 est rev B revB dwg 07.04.18 ec

Additional Product



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.3759 sf(s)/Unit Total : 7.5180 sf(s)
 304/316 .060 Sheet
 Batch: 105997 B07-12-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3565
 Dwg Rev: TRIAL ORD
 Prog Rev: TRIAL ORD B07-12-19
 2-Deburr if necessary B07-12-19



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Handwritten signature and date 12.19, circled 'S', and word 'counted'.

5.0 D30093 CUP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)
 CUP
 Batch: B36431

Handwritten 'FC 07/12/20' and circled 'S'.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/09	2	8 parts scrap - New D&F req'd						

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3565 *FC*

2-Weld hard facing as per Dwg D3565 *FC*

A/R 2059B Hard Coat rod

Batch:

M105454

FC 07/12/21 (5)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07-12-21
PBL QCS*

07-12-21 (5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105642

07-12-21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/12/21 (SX)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/12/21 (SX) SQ

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/03

Job Completion



2008/1/2

POSITIVE RECALL

EFFECTIVE

07/12/19

AUTH

U

RELEASED

1

DATE

07.12.21

Dart Aerospace Ltd

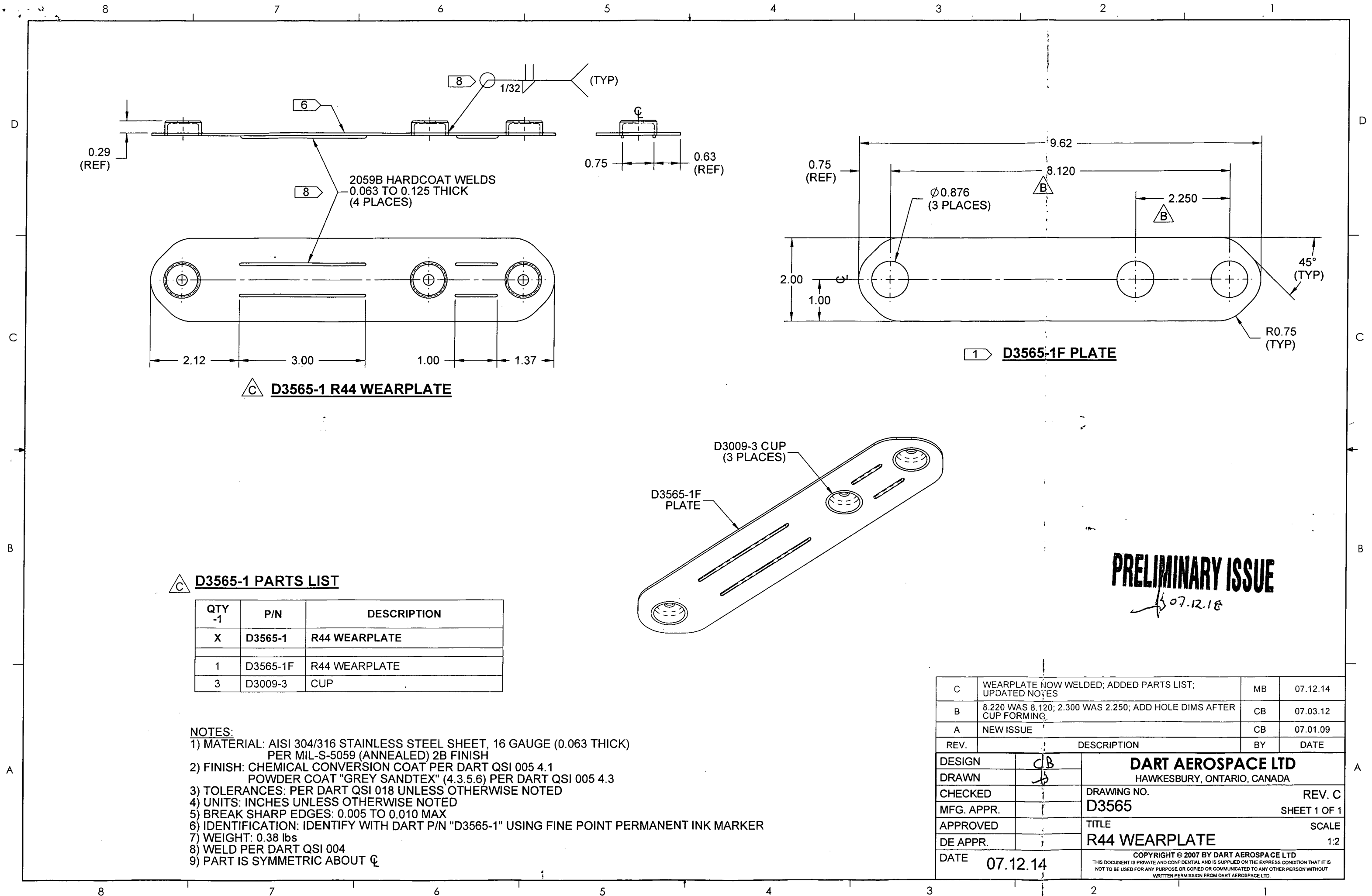
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE

D3565-1F PLATE

D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	R44 WEARPLATE
3	D3009-3	CUP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.38 lbs
 - 8) WELD PER DART QSI 004
 - 9) PART IS SYMMETRIC ABOUT Q

PRELIMINARY ISSUE
07.12.18

C	WEARPLATE NOW WELDED; ADDED PARTS LIST; UPDATED NOTES	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3565	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		R44 WEARPLATE	1:2
DATE	07.12.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

